

Work Order ID 71885

Wednesday, July 13, 2011 11:09:27 AM

Page 1

Item ID: D3953-7

Accept

Setup Start

Revision ID:

Item Name: Spring Spacer

Stop

Start Date: 7/14/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 11-07-13

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA854 & DWG

FOLIO REV:

DWG REV: C

DEBURR

SL 11/8/4

20 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 11/8/4

20 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71885

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Page 2

Item ID: D3953-7

Accept



Setup Start



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Stop



Start Date: 7/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

ref 11/08/09



QC

Memo

0.00

20

Quality Control

130

Identify as per dwg & Stock Location: *96*

0.00



Packaging

Memo

0.00

11/8/09 20

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/08/09 20

Quality Control

11-08-11 (20)

Dart Aerospace Ltd

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Picklist Print

Wednesday, July 13, 2011 11:09:25 AM

Page 1

Work Order ID: 71885



Parent Item: D3953-7



Parent Item Name: Spring Spacer

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MDELNR0.750

Purchased

No

100

f

42.7980

0.05

1.052632



52 41814

Delrin Round Bar 0.75"

Location

Loc Qty

Loc Code

MAT055

42.798

115472

7.5

116183

2.4

117273

9.958

117322

0.94

118066

22

82K

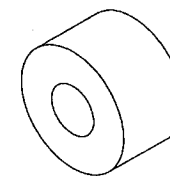
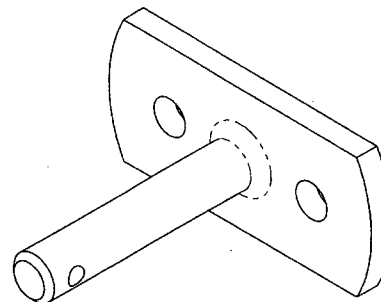
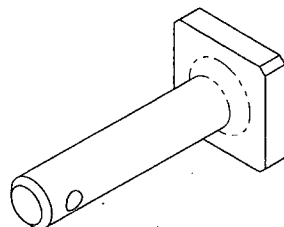
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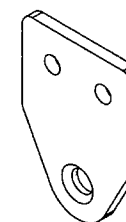
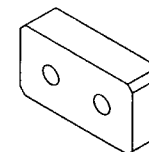
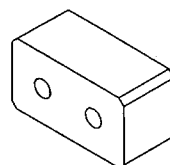
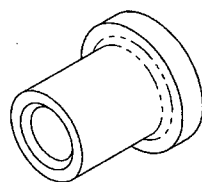
D3953-1 GAS SPRING BRACKET
(FULL LID)

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER



RELEASED
R 2010-02-26

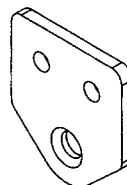
D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER
(FULL LID)

D3953-15 GAS SPRING BRACKET
(SPLIT LID)

D3953-17 GAS SPRING SPACER
(SPLIT LID)

D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

#71885

C	PARTS -19 & -21 ADDED (SHT 18 & 4); CSK CALLOUT WAS CHAM (C5-2, B6-3, C6-4); G SYMM WAS G SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO 82-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEWISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV.
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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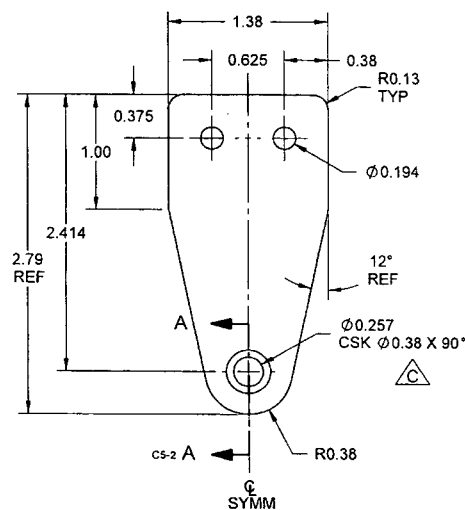
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

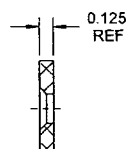
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NOTE: Date & initial all entries

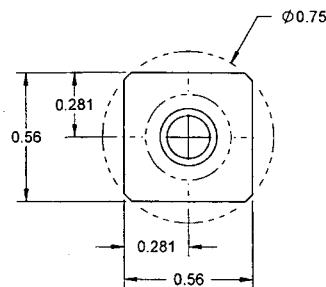
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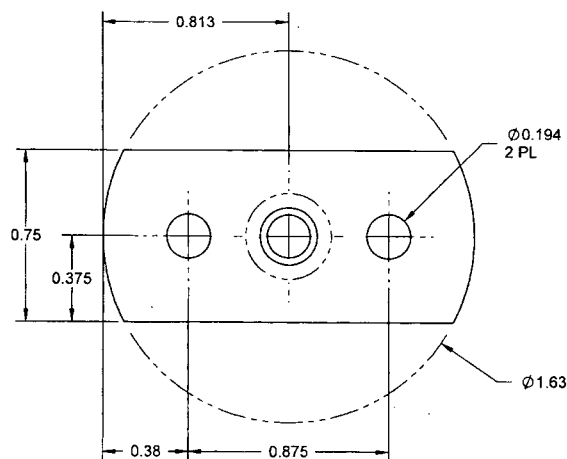
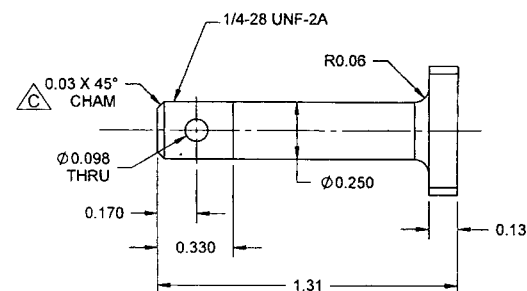
D3953-1 GAS SPRING BRACKET
(FULL LID)



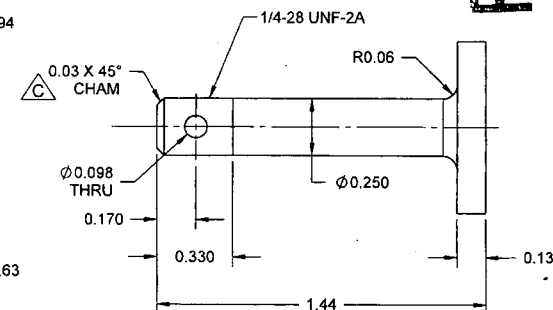
SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
OR:
AIS1 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.11 lbs
-3: 0.03 lbs
-5: 0.06 lbs

#71885

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	g	DRAWING NO.	REV. C
MFG. APPR.	B	D3953	SHEET 2 OF 4
APPROVED	#	TITLE	SCALE
DE APPR.	#	GAS SPRING LID COMPONENTS	NTS
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R 2010-02-26

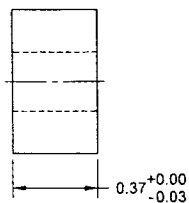
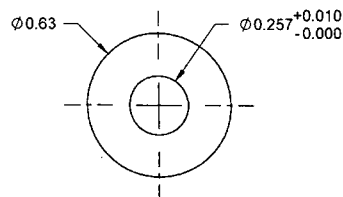
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

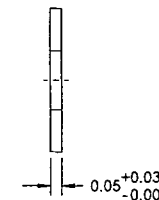
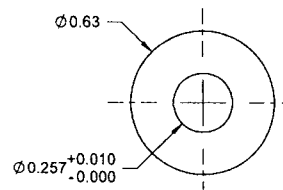
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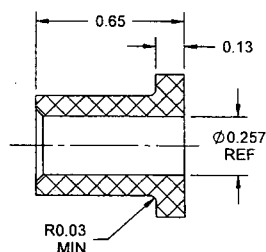
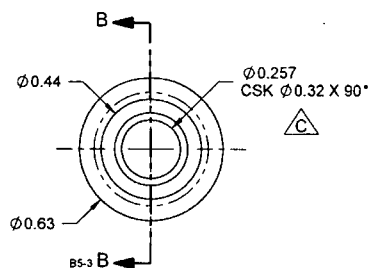
NOTE: Date & initial all entries



D3953-7 GAS SPRING SPACER

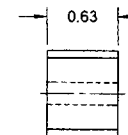
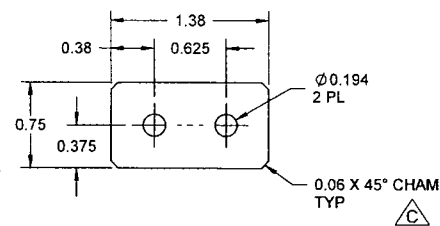


D3953-9 GAS SPRING WASHER



SECTION B-B 87-3

D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

#71885

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2010-02-26

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV: C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	
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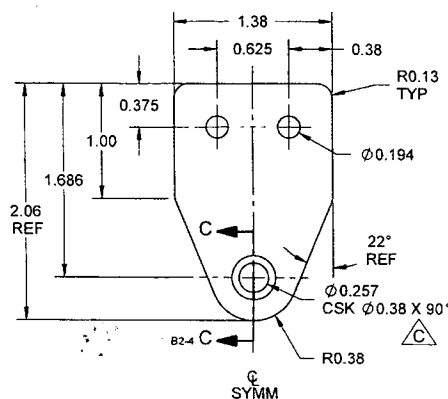
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

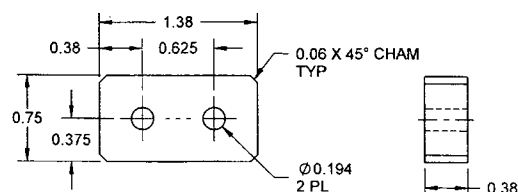
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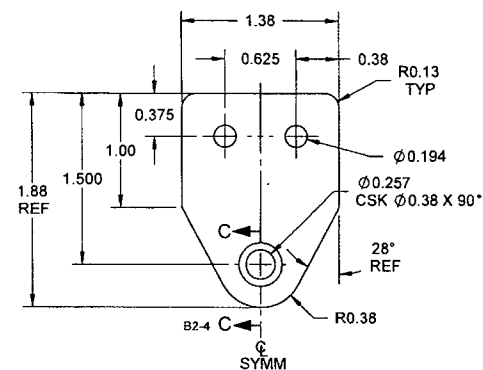
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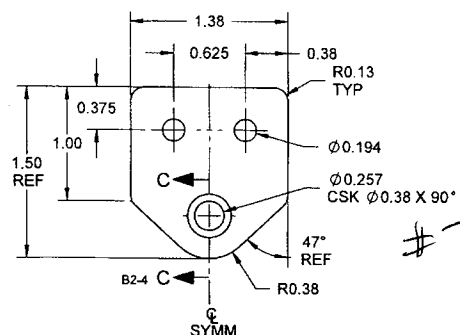
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



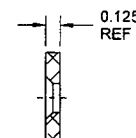
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

NOTES:

- 1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH.
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ	
C	10.06.07	Tolerance revised for dimension 0.37	KJ	

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